

54700 De Rev

Work Order ID 53791



Page 1

November 18, 2009 12:41:49 PM

Item ID: D2855

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 18/11/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PLDate: 09/11-18

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10794 ☐ Cast per Dwg D2855 ☐ Material Release Note
Required09/11/18 100

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

09/12/3 118

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

→ Sorlizloy
QSP019

Counter

118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53791

November 18, 2009 12:41:49 PM



Page 2

Item ID:	D2855	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Cap					
Start Date:	18/11/2009	Start Qty:	100.00		Cust Item ID:	
Required Date:	25/11/2009	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00				<u>118X</u>			
Small Fab	Memo	0.00							
Small Fab	1- Drill as per Dwg D2855 using DT8235□2- Open holes to 19/64"□3- Deburr								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				<u>118</u>			
Quality Control									
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:20								
	320° FINISH TIME: 3:50								

→ M. L 09/12/07

→ S 09/12/08

BL 09-12-10 118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		22/11/11						

NOTE: Date & initial all entries

Work Order ID 53791

November 18, 2009 12:41:49 PM



Item ID: D2855

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 18/11/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	09/12/14			X118	0		
170 Small Fab Small Fab	Small Fab Memo Install Inserts as per Dwg D2855	0.00 0.00	09-12-16			X118	0		
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 805/12/16			counter 6006			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 53791



November 18, 2009 12:41:49 PM



Page 4

Item ID: D2855 Accept  Setup Start 
Revision ID: A
Item Name: Cap Stop 
Start Date: 18/11/2009 Start Qty: 100.00  Cust Item ID:
Required Date: 25/11/2009 Req'd Qty: 100.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Packaging	Identify as per dwg & Stock Location: <u>FP-6</u> Memo	0.00		<i>09-12-16</i>		<i>x 128</i>	<i>q</i>		
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							<i>09/12/17</i> <i>MF 09-12-16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

November 18, 2009 12:41:56 PM

Work Order ID: 53791

Parent Item: D2855RevA

Parent Item Name: Cap

Comments:

Start Date: 18/11/2009

Required Date: 25/11/2009

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	877.0000	200.0000			

INSERT



Warehouse

Loc Qty

Loc Code

Location

M 110768

X136 M 09/12/16

Main Warehouse

ST

877

100895

21

100896

102

102018

102

110118

52

111529

300

111581

300

D2855PRevA

Purchased

No

170

Each

0.0000

100.0000



Cap



09/12/13

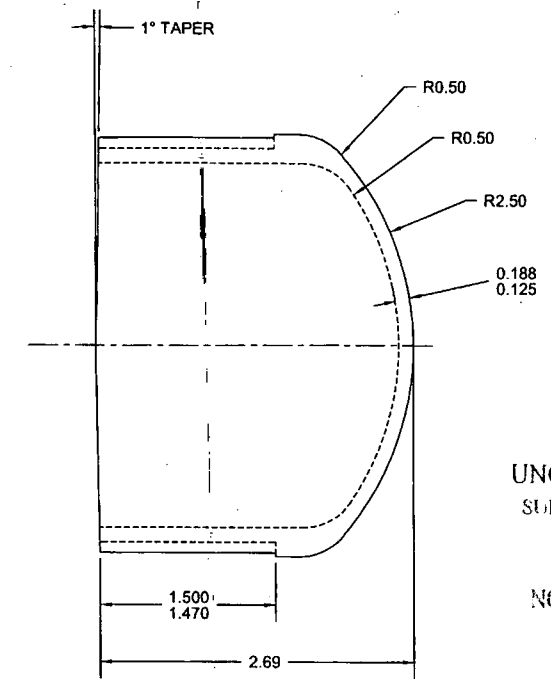
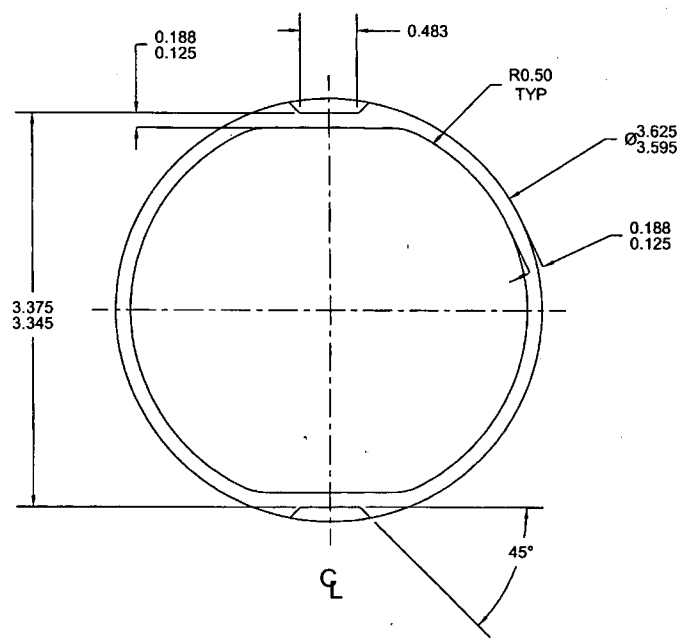
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries






SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53291
B109-11-18

D2855C CASTING DETAIL B

RELEASED
09/12/15 MJB

- NOTES:**
- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)		RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)		DS	96.12.12
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.		D2855	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		CAP	NTS	
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

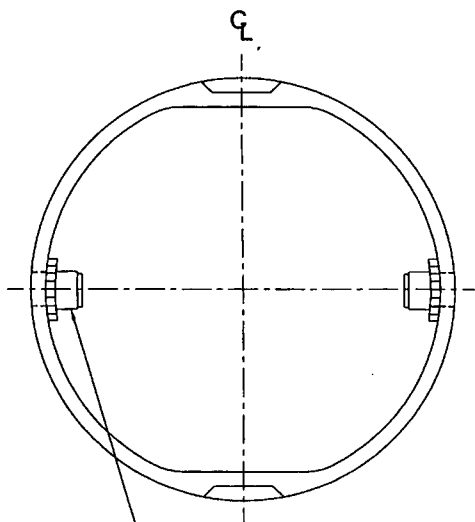
8 7 6 5 4 3 2 1

D

C

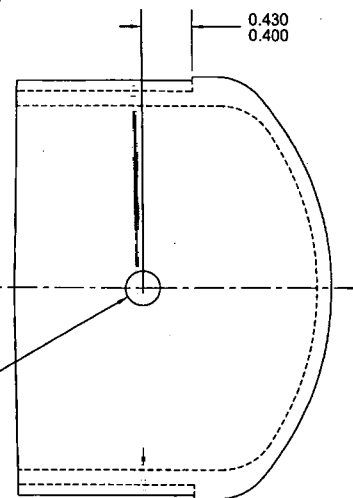
B

A



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

Ø0.297
2 PL



D

C

B

A

D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
9/17/15

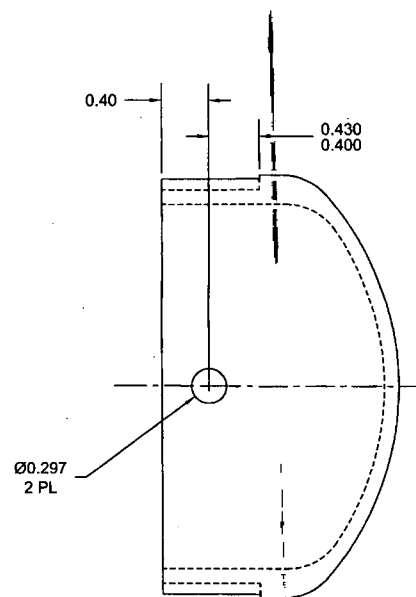
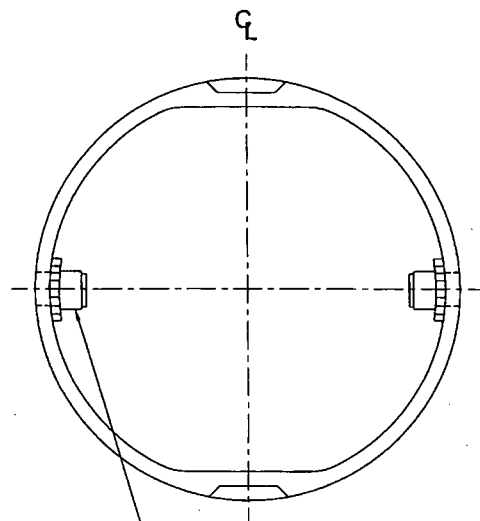
W/0 53791

NOTES:


- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1







INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
09/16/13

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10794

Purchase Order Date 11/18/09

PO Print Date 11/18/09

Page Number 1 of 1

Order From :

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

FAXED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 683 9777	Requisition Nbr	
Vendor Fax	514 683 0375	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P B	Cap	11/30/09 Yes	100.00 Each	FedEx Economy <i>Nec 118</i>	\$16.9000	\$1,690.00

Special Inst: AS PER DWG D2855 REV. A
B53791
MATERIAL: CASTING ALUMINUM
ALLOY A356.2 (F)

PO Total: \$1,690.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 11/18/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

2225 Chemin St. Francois
Dorval, Québec H9P 1K3
Tel: (514) 683-9777
Fax: (514) 683-0375
email: info@foundryafpw.com

Packing Slip

Packing Slip No.:
Shipped Date:

33214
Nov 27, 2009

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 10794	
Shipped By:	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	118
<p style="text-align: center;">8 02/12/04</p> <p style="text-align: center;">Received by:</p> <p style="text-align: center;">Date:</p>			
<p>Comment:</p>			

**CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE**

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **27/11/2009** Slip No. **33214**
Hawksbury, ON, K6A 1K7

Vôtre No. Commande **10794**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
118pcs	D 2855 CAP	Z098046	A356.2 <i>8 09/12/04</i>	ingot#0853478
Analyse Analysis (as in ingot) (Si) 7.17% (Al) balance (Fe) 0.087% (Cu) 0.0024% (Mn) 0.0017% (Mg) 0.37% (Zn) <0.001% (Ti) 0.16%				
Donne Yield :	Résistance a la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %		

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100